

Work Order ID **158809**

158809

Page 1

Friday, March 31, 2017 7:15:36 PM

Item ID: D5355-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Clamp Assembly
 Start Date: 4/4/2017 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 4/6/2017 Req'd Qty: 6.00 ***6*** Customer:
 Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5355	C

100	BAND SAW	0.00							DAS 08 9-05
100									
Bandsaw	Memo	0.06	B.A	17-04-08		6	φ		
Jeaspa Bandsaw	Cut Blanks at 6.200"								

110	HAAS CNC VERTICAL MACHINING #1	3.20							DAS 08 9-09
110									
HAAS 5AXIS	Memo	2.19	B.A	17-04-08		6	φ		
HAAS CNC vertical machine #5	1-Machine per folio FB434 DWG REV: <u>C</u> FOLIO REV: <u>BA</u>								

2- deburr and break all sharp edge as per dwg

Work Order ID 158809

Friday, March 31, 2017 7:15:36 PM

158809

Page 3

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.12							
Packaging	Certification of Conformity is required.								
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.12							
Quality Control									

6x SP17-511

6

DAS
38
9-88

MAY 11 2017

Friday, March 31, 2017 7:15:36 PM

158809

Page 4

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Aft Clamp Assembly

Start Date: 4/4/2017 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 4/6/2017 **Req'd Qty:** 6.00 ***6***

Customer:

Reference: SCHEDULED

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

3.68

Small Fab

Small Fab

Memo

-Assemble as per dwg.

-Secure nuts as per dwg. (Note #8)

-Apply proseal as per dwg.(Note #9)

Batch: 136953

Exp. date: 10/17

MAY 16 2017

DAS
19
9-89

170

QC5- Inspect part completeness to step on W/O

0.00

170

0.12

QC

Memo

Quality Control...

DAS
38
9-28
MAY 16 2017

Work Order ID 158809

Friday, March 31, 2017 7:15:36 PM

158809

Page 5

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Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: 85/6	0.00				6	DAS 6 9-89	MAY 17 2017	
180									
Packaging	Memo	0.06							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.60							17/5/17
Quality Control									

DAS
21
9-89**MAY 17 2017**

Picklist Print

Friday, March 31, 2017 7:15:35 PM

Page 1

Work Order ID: 158809

158809

Parent Item: D5355-041

D5355-041

Parent Item Name: Aft Clamp Assembly

Start Date: 4/4/2017

Required Date: 4/6/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 16.01.05 NEW ISSUE DD VERF:JLM IPP
REV:B 16.01.26 REV.A DWG DD VERF:JLM IPP REV:C
16/07/12 Per rev.B dwg. JFS Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5316-1		Manufactured	No			160	Each	9.0000	1	6		MAY 16 2017	DAS 19 9-89

D5316-1

T-Bolt Strap

Location Loc Qty Loc Code

ST163

9

155235

9

D5351-1

Manufactured No

160

Each

0.0000

2

12

MAY 16 2017

DAS
19
9-89

D5351-1

T-Bolt Spacer

M6061T6B1.250X04.50
0

Purchased No

100

f

8.0764

0.517

3.265263

M6061T6B1 250X04 500

6061-T6 Bar 1.25 X 4.50

Location Loc Qty Loc Code

MAT004

8.0764

m133038

0.3014

→ m134776

7.775

3.125 +

Picklist Print

Page 2

Friday, March 31, 2017 7:15:35 PM

Work Order ID: 158809

158809

Parent Item: D5355-041

D5355-041

Parent Item Name: Aft Clamp Assembly

Start Date: 4/4/2017

Required Date: 4/6/2017

Start Qty: 6.00

Required Qty: 6.00

MS21043-3

Purchased

No

160

Each

936.0000

2

12

MS21043-3

**

MAY 16 2017

DAS
19
9-89

Nut

LocationLoc QtyLoc Code

FG	80	
103691	80	
FP001	203	
m130673	11	
m136182	192	
GA	215	
m133990	27	
m136182	188	
ST302	369	
m136986	369	
ST304	69	
m131340	69	

NAS1149D0332J

Purchased

No

160

Each

1,682.000

2

12

NAS1149D0332.J

**

MAY 16 2017

DAS
19
9-89

Washer

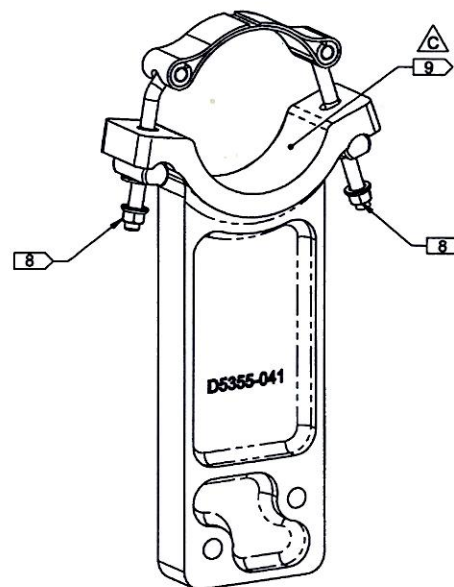
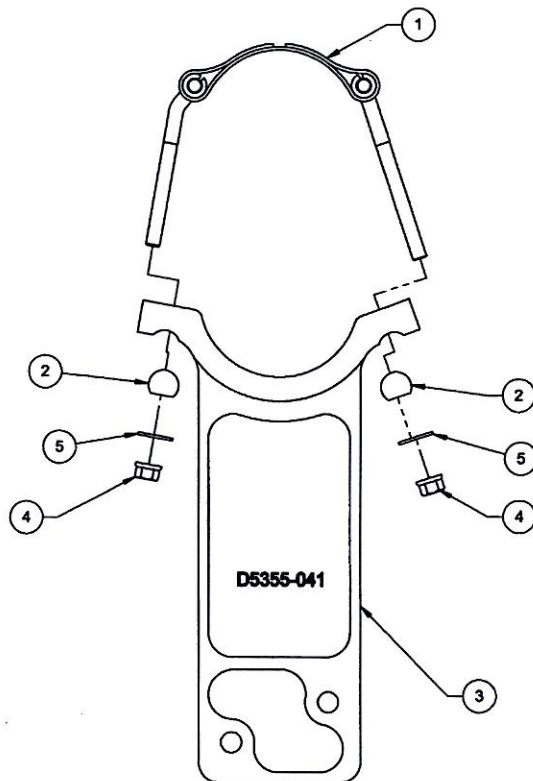
LocationLoc QtyLoc Code

FP	28	
m136015	28	
GA	522	
m136643	522	
ST260a	1000	
m137075	1000	
ST264	132	
m136015	132	

Friday, March 31, 2017 7:15:35 PM

Shop Packet Print

Page 2



ITEM	QTY	P/N	DESCRIPTION
	X	D5355-041	R66 AFT CLAMP ASSY
1	1	D5316-1	T-BOLT STRAP
2	2	D5351-1	T-BOLT SPACER
3	1	D5355-1	SUPPORT
4	2	MS21043-3	NUT, SELF-LOCKING
5	2	NAS1149D0332J	WASHER
6	A/R	PROSEAL 890	SEALANT

D5355-041 R66 AFT CLAMP ASSY

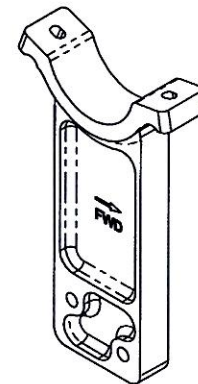
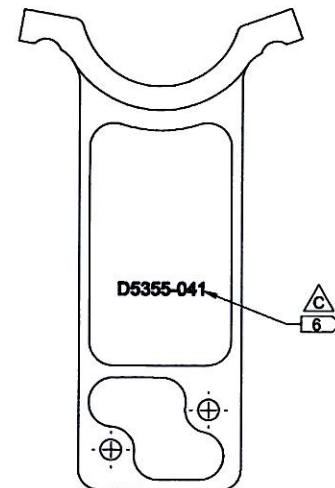
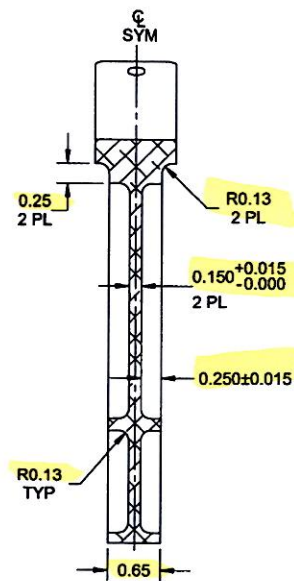
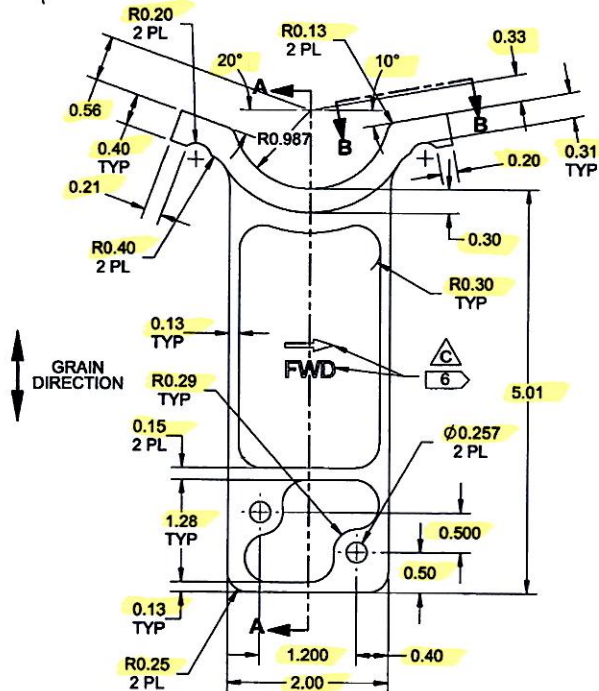
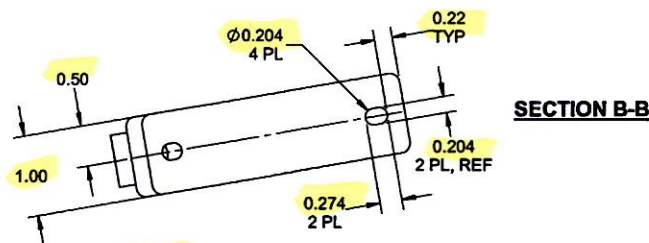
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: AS SHOWN ON D5355-1
- 7) WEIGHT: 0.51 lbs
- 8) SECURE NUTS WITH 1-2 THREAD AS SHOWN
- 9) APPLY AN EVEN LAYER OF PROSEAL 890 (0.02" - 0.03" THICK) ON INSIDE SURFACE

RELEASED
2017-03-22
ECN 17-535

C	ADDED ENGRAVING, REVISE NOTE 6 AND LOCATION OF PROSEAL (ZN A8-1, C3-1 A8-2, B3-2, B6-2)	RF	17.02.09
B	REDESIGN -1/-041 (ZN B5-1, B5-2); ADD NOTE 9 (ZN A8-1); REMOVE -043	RF	16.05.24
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JFS	D5355	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 AFT CLAMP ASSY	NTS
DATE	17.02.09	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH ASSEMBLY P/N, FWD & ARROW PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.43 lbs
- 8) UNDEFINED FEATURES CONTROLLED BY CAD FILE D5355-1 Rev. C.SLDPRT

D5355-1 SUPPORT

RELEASED
2017-03-22

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D5355	REV. C
MFG. APPR.	JFS	SHEET 2 OF 2	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 AFT CLAMP ASSY	NTS
DATE	17.02.09	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 158809
Description: SUPPORT		Part Number: D5355-1
Inspection Dwg: D5355 Rev: C		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/- .030	1.000	✓		Vern	GA-13
0.50	+/- .030	0.497	✓		"	"
φ0.204	+ .005 / - .001	φ0.204	✓		"	"
0.22	+/- .030	0.221	✓		"	"
0.204	+/- .010	0.204	✓		"	"
0.274	+/- .010	0.271	✓		"	"
0.31	+/- .030	0.317	✓		"	"
0.20	+/- .030	0.201	✓		"	"
0.33	+/- .030	0.330	✓		H-6	31006
10°	+/- 1/2°	10°	✓		Angle M.	CNC-17
R0.13	+/- .030	R0.125	✓		R-6	ref.
20°	+/- 1/2°	20°	✓		Angle M.	CNC-17
R0.20	+/- .030	R0.203	✓		R-6	ref.
0.56	+/- .030	0.560	✓		H-6	31006
0.40	+/- .030	0.399	✓		Vern	GA-13
0.21	+/- .030	0.213	✓		"	"
R0.40	+/- .030	R0.406	✓		R-6	ref.
0.13	+/- .030	0.125	✓		Mic	GA-03
R0.29	+/- .030	R0.297	✓		R-6	ref.
0.15	+/- .030	0.150	✓		Mic	GA-03
1.28	+/- .030	1.275	✓		Vern	GA-13
0.13	+/- .030	0.125	✓		Mic	GA-03
R0.25	+/- .030	R0.250	✓		R-6	ref.
1.200	+/- .005	1.199	✓		H-6	31006
2.00	+/- .030	1.999	✓		Vern	GA-13
0.40	+/- .030	0.401	✓		"	"
0.50	+/- .030	0.499	✓		H-6	31006
0.500	+/- .005	0.500	✓		"	"
φ0.257	+ .006 / - .001	φ0.258	✓		Vern	GA-13
5.01	+/- .030	5.013	✓		H-6	31006
R0.30	+/- .030	R0.297	✓		R-6	ref.
0.30	+/- .030	0.300	✓		Vern	GA-13

Measured by: H.A. DAS 08	Checked by: 14 9-89	QC Inspector:
Date: 17-04-08 9-89	Date: 17/04/11	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER
Purchase Order ID PO36011

Purchase Order Date 4/19/2017
PO Print Date 4/25/2017

Page Number 4 of 5

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-446-4544

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

10 158807 D5354-042 R66 CLAMP 5/5/2017 3.00
REV. C Yes

Line Total: \$7.5

\$2.50 \$7.5

BLACK ANODIZE AS PER MIL-A-8625F TYPE 1 OR IB/IC/II/IIB CLASS 2

Line Total: \$7.5

11 158809 D5355-041 AFT CLAMP 5/5/2017 6.00
REV. C Yes

\$3.25 \$19.

BLACK ANODIZE AS PER MIL-A-8625F TYPE 1 OR IB/IC/II/IIB CLASS 2

Line Total: \$19

12 158757 647.7910 ANGLE 5/5/2017 8.00
BRACKET REV. N/C Yes

\$3.60 \$28

BLACK ANODIZE AS PER MIL STD-A-8625 TYPE III, CLASS 2

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

4/25/2017



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913270

Date: 05-May-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
3 ea	Part: D5354-042 R66 Clamp Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20964	Rev: C PO: PO36011	Line: 10
6 ea	Part: D5355-041 Aft Clamp Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20965	Rev: C PO: PO36011	Line: 11
8 ea	Part: 647.7910 Angle bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Job: 20966	Rev: N/C PO: PO36011	Line: 12
1 ea	Part: ADMINISTRATION FEE Administrative Fee Job: 20967	Rev: N/A PO: PO36011	Line: 13
6 ea	Part: 647.3912 Breakaway Tip Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20956	Rev: C PO: PO36011	Line: 2
6 ea	Part: 647.3912 Breakaway Tip Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20957	Rev: C PO: PO36011	Line: 3
6	Part: 647.3914	Rev: C	
Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913270

Date: 05-May-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		OUR TRUCK
Quantity	Description	
	Date: <u>05/05/2017</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>[Signature]</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
Made in Canada.		